



Dart Aerospace Ltd.
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Tel (613) 632-5200

D4292-1
Job Sheet 172932



Part No: D4292-1

Job Qty: 4 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/9/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/8/18	0.00	0.00	Start Up Machining-2		18-03-07
100	Bandsaw	4 pcs		3/8/18	0.00	0.34	Bandsaw1		
110	CNC Vertical Machining	4 pcs		3/8/18	0.51	8.23	HAAS 5 Axis		
120	QC	4 pcs		3/8/18	0.00	0.00	QC2 Machining-2		3C-1
130	QC	4 pcs		3/8/18	0.00	0.00	QC8 Machining-2		
140	HandFinish	4 pcs		3/8/18	0.00	0.22	HandFinish1		18-03-07
145	Powdercoat	4 pcs		3/8/18	0.00	0.30	Powdercoat1		18-03-10
150	QC	4 pcs		3/8/18	0.00	0.00	QC3		38
151	Small Fab	4 pcs		3/9/18	0.00	0.18	Small Fab-6		9-89 DAS
152	QC	4 pcs		3/9/18	0.00	0.00	QC5		38
180	Packaging	4 pcs		3/9/18	0.00	0.00	Packaging3-2		DAS 9-89
190	QC21-SA	4 Ea		3/9/18	0.00	0.00	QC21		6

Part Op 100 - Cut Blank to 6.250" ****GRAIN DIRECTION MUST BE ALONG 4.00*****
Descriptions: 110 - 1-Machine per folio FB002
145 - MASK THREADED HOLE
151 - INSTAL HELICOIL

DAS
21
9-89

MAR 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B4.000x4.000	7075-T73 Bar 4.0 X 4.0 Grain Direction Along 4"	2.0800 ft (.52 ea)	90-Start up Operation	
MS21209F1-10	Heli Coil	4 Ea (1 ea)	151-Small Fab	

S047871

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B4.000x4.000	2	48	0
151-Small Fab	MS21209F1-10	4	57	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
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Container No: S048635



Part: D4292-1

Job No: 172932

Serial No/Batch: S048635

Revision:

Inspector:

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Date: 03/07/18

DART AEROSPACE LTD	Work Order:	172 932
Description: Fitting	Part Number:	D4292-1
Inspection Dwg: D4292 Rev: C		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/-0.010	.063	✓		Rad gauge	
0.250	+0.030/-0.010	.249	✓		SLIO	vein
0.125	+0.030/-0.010	.124	✓			
2.95	+/-0.030	2.944	✓			
0.275	+/-0.010	.273	✓			
0.800	+/-0.010	.801	✓			
0.825	+/-0.010	.825	✓			
0.375	+/-0.010	.373	✓			
0.31	+/-0.030	.310	✓			
0.88	+/-0.030	.870	✓			
0.663	+/-0.010	.663	✓			
Ø0.381	+0.000/-0.001	.380	✓			
1.125	+/-0.010	1.125	✓			
1.063	+/-0.010	1.063	✓			
3.44	+/-0.030	3.438	✓			
2.450	+/-0.010	1.324	✓			
1.325	+/-0.010	2.450	✓			
0.300	+/-0.010	.301	✓			
1.200	+/-0.010	1.200	✓			
2.84	+/-0.030	2.835	✓			
0.19	+/-0.030	.188	✓			
5.86	+/-0.030	5.857	✓			
5.99	+/-0.030	5.985	✓			
Ø0.272	+0.006/-0.001	.272	✓			
Ø0.266	+0.006/-0.001	.266	✓			
1.75	+/-0.030	1.748	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
R0.06	+/-0.030	.060	✓		"	
4.875	+/-0.010	4.875	✓			
0.493	+/-0.010	.492	✓			
C-bore Ø0.765	+/-0.010	.765	✓			
0.250	+0.030/-0.010	.250	✓			
0.680	+/-0.010	.678	✓			
2.250	+/-0.010	2.250	✓			
4.500	+/-0.010	4.500	✓			
R1.275	+/-0.010	1.275	✓		Rad gauge	
R0.031	+/-0.010	.0315	✓		"	

